

SPLIT

Work Order ID 77013-1

\*77013\*

Page 1

Thursday, November 24, 2011 3:21:10 PM

Item ID: D4155-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bar

Start Date: 11/24/2011 Start Qty: 8.00

\*8\* 2

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 8.00

\*8\* 2

Customer:

Reference:

Approvals: Process Plan:

Date: 11/24/11

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4155

B

100

0.00

\*100\*

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 91.75"

110

0.00

\*110\*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB048 & dwg D4155.

FOLIO REV: \_\_\_\_\_

DWG REV: \_\_\_\_\_

2-Deburr as required

Handwritten signature

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Run Start

\*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

140

0.00

\*140\*

Small Fab

Memo

0.00

Small Fab

Grind off chamfer on fwd end of bar as per dwg

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\*8\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: *w/1*

0.00

\*160\*

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

QC

Memo

0.00

Quality Control

*11/12/14*

*ME*

*11-12-14*

# Picklist Print

Page 1

Thursday, November 24, 2011 3:21:14 PM

Work Order ID: 77013

\*77013\*

Parent Item: D4155-1

\*D4155-1\*

Parent Item Name: Bar

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A 10.08.03 new issue DD ver:EC  
11.04.14 as per dwg revB DD ver:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.250x0.500

Purchased

No

100

f

1,035,416

7.6333

64,28042

\*\*

**\*M304B0 250x0.500\***

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

997.522

117842

8.3

119050

21.67

119159

967.552

MAT050

37.8947

117176

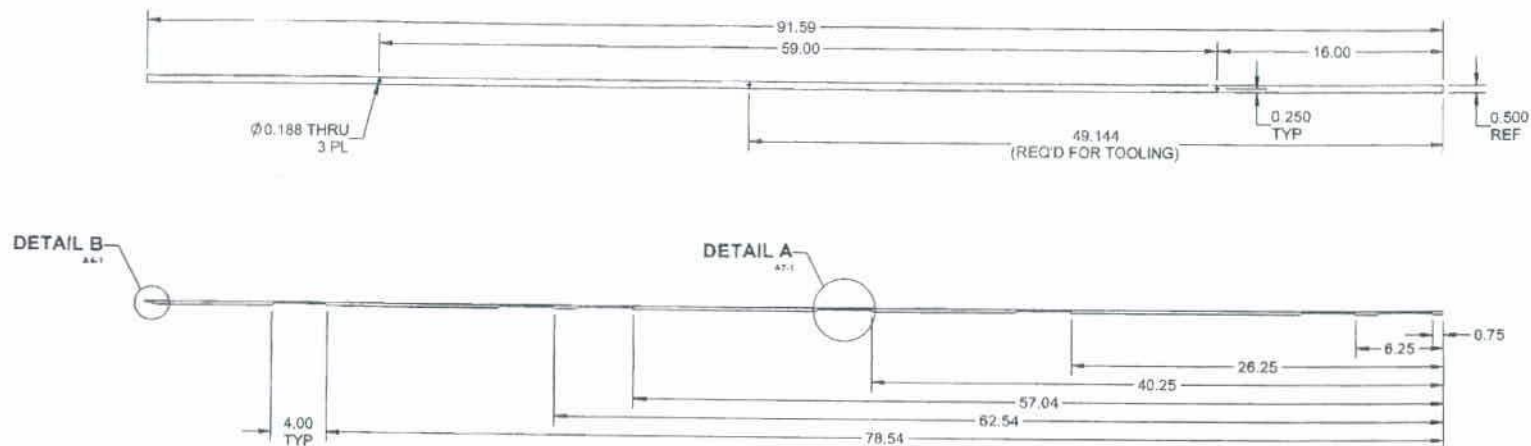
37.8947

M304 B 0.25 x .500

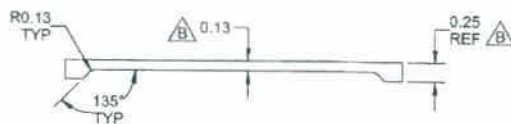
8 11/24/11



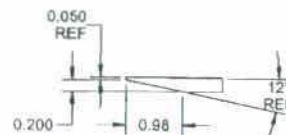




**D4155-1 BAR**



**DETAIL A**  
SCALE 2X, TYP



**DETAIL B**  
SCALE 2X

**RELEASED**  
2011-04-13

**NOTES:**

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240  
REF. DART SPEC. M304B0.250X00.500
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.82 lbs

DESIGN	CHANGED MANUFACTURING PROCESS, MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
DRAWN	NEW ISSUE	SC	10.07.22
CHECKED	DESCRIPTION	BY	DATE
MFG. APPR.	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA		
APPROVED	DRAWING NO. <b>D4155</b>	REV. B	SHEET 1 OF 1
DE APPR.	TITLE <b>BAR</b>	SCALE NTS	
DATE	11.04.05	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE FURTHER UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	